

Work Order ID 62477

Page 1

Thursday, September 30, 2010 2:20:42 PM

Item ID: D3763-045

Accept



Setup Start



Revision ID:

Item Name: End Fitting Assembly

Stop



Start Date: 9/30/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/8/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-9-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3763	Rev B

100 Pick Kit 0.00



Packaging

Memo

0.00

PL 10-06-10

Packaging

110



Large Fab

0.00

PL 10-11-10

Large Fab

Memo

0.00

1-make a 0.063" chamfer on D3763-1 fitting before ass'y. 2-assemble and tack weld as per dwg D3763 using locating pin DT9039. ***remove pin before welding*** 3-weld as per dwg D3763 , QSI004 Alum. rod
Batch: 1112860

120



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

2 1 BE 10/11/10

Pto →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3763-045 PAR #: Fault Category: Long Fis NCR: Yes No DQA: Date: 10/11/10
 Resolution: SCWP Disposition: SCWP QA: N/C Closed: Date: 10/11/11

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/11/10	#10	Crack in D37631 From welding. PC Process (within thick part to thin part)	J 10/11/10	- Scrap + destroy no replace	J 10/11/10	S 10/11/10	J 10/11/10	S 10/11/10

NOTE: Date & initial all entries

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Page 2

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Reference:

Approvals:

Process Plan:

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

S (a) u / 10



QC

Memo

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

→ M 101111



HandFinish

Memo

Hand Finishing

150

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

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Page 3

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Setup

Start



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Item Name: End Fitting Assembly

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Start Date: 9/30/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/8/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 251A

0.00

Packaging

Packaging

170



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, September 30, 2010 2:20:46 PM

Page 1

Work Order ID: 62477



Parent Item: D3763-045



Parent Item Name: End Fitting Assembly

Start Date: 9/30/2010

Required Date: 10/8/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-07-18 new issue DD verified by:ec
IPP Rev:B 08-08-11 add chemical coat and qc3 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3763-7 		Manufactured	No			100	Each	10.0000	1	4		<i>PL 10-10-10</i>	

Tube

Location	Loc Qty	Loc Code
ST251A	10	
54381	10	

D3763-1

Manufactured No

110 Each 19.0000

(3)
PL 10-11-10

End Fitting

Location	Loc Qty	Loc Code
ST251	3	
60499	3	
WA	16	
61722	4	
61826	12	

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

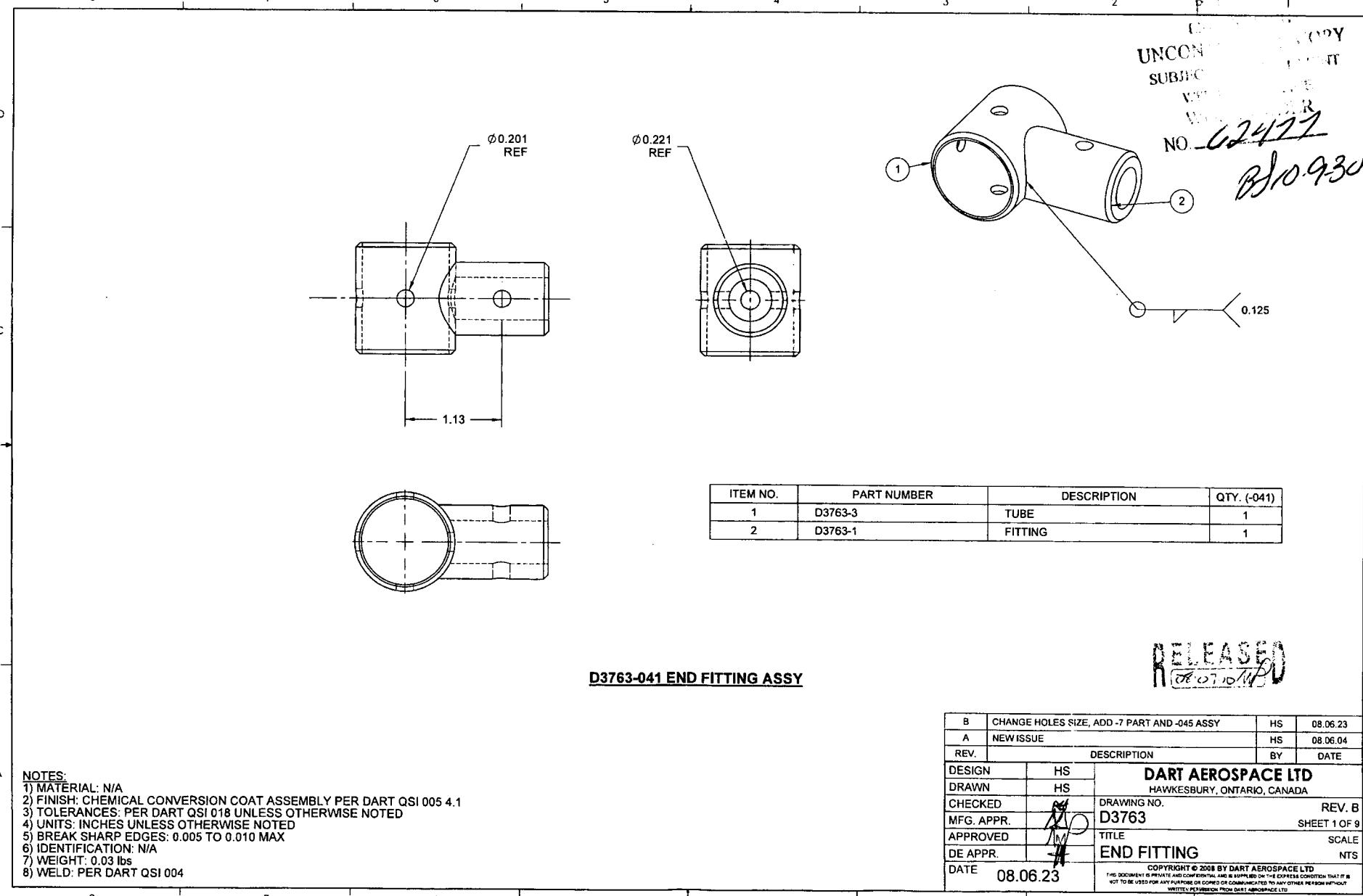
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NOTE: Date & initial all entries

SHEET 1 OF 1

UNCONVENTIONAL
SUBJECTNO. 62477
B10.930

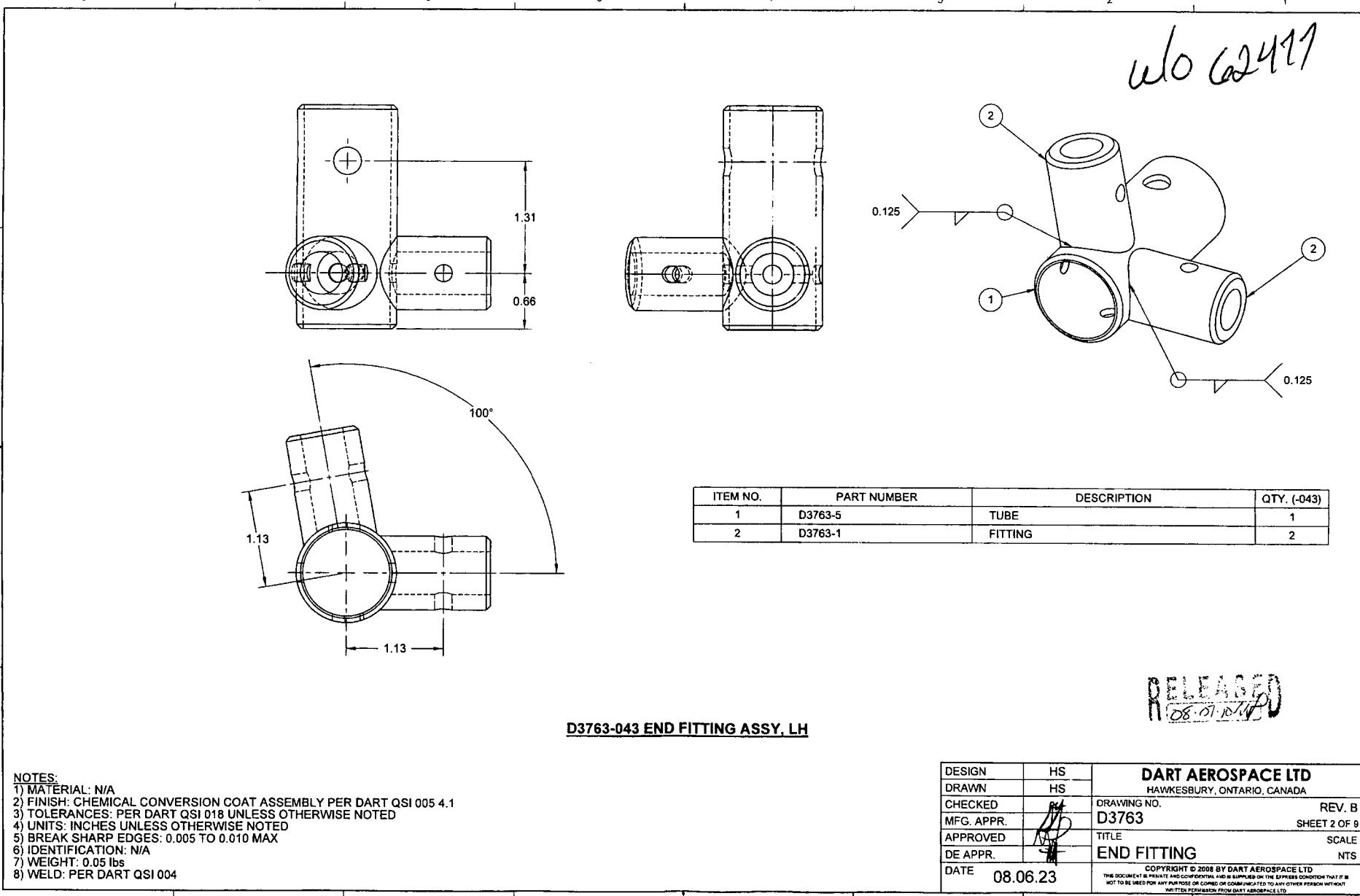
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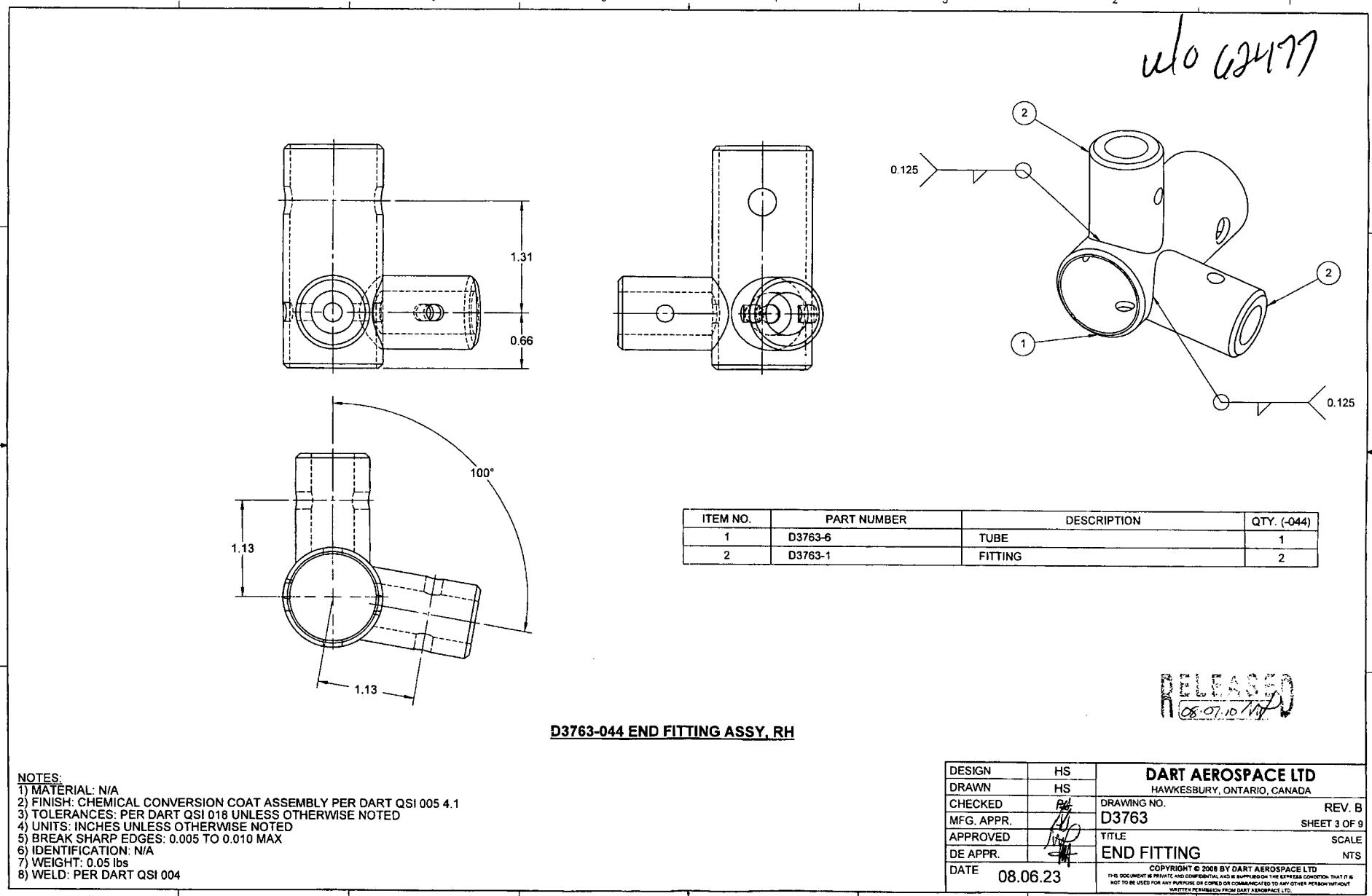
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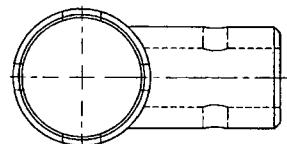
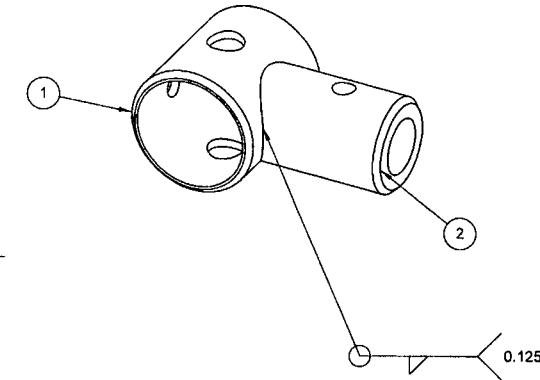
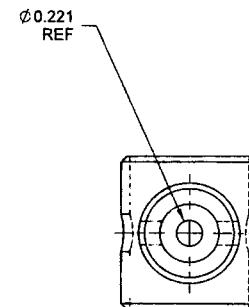
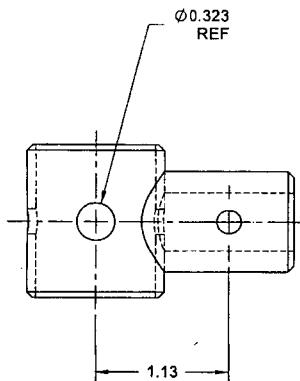
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NOTE: Date & initial all entries

w662477



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3763-7	TUBE	1
2	D3763-1	FITTING	1

D3763-045 END FITTING ASSY

RELEASED
08/07/10

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs
8) WELD: PER DART QSI 004

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3763	SHEET 4 OF 9
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DE APPR.		END FITTING	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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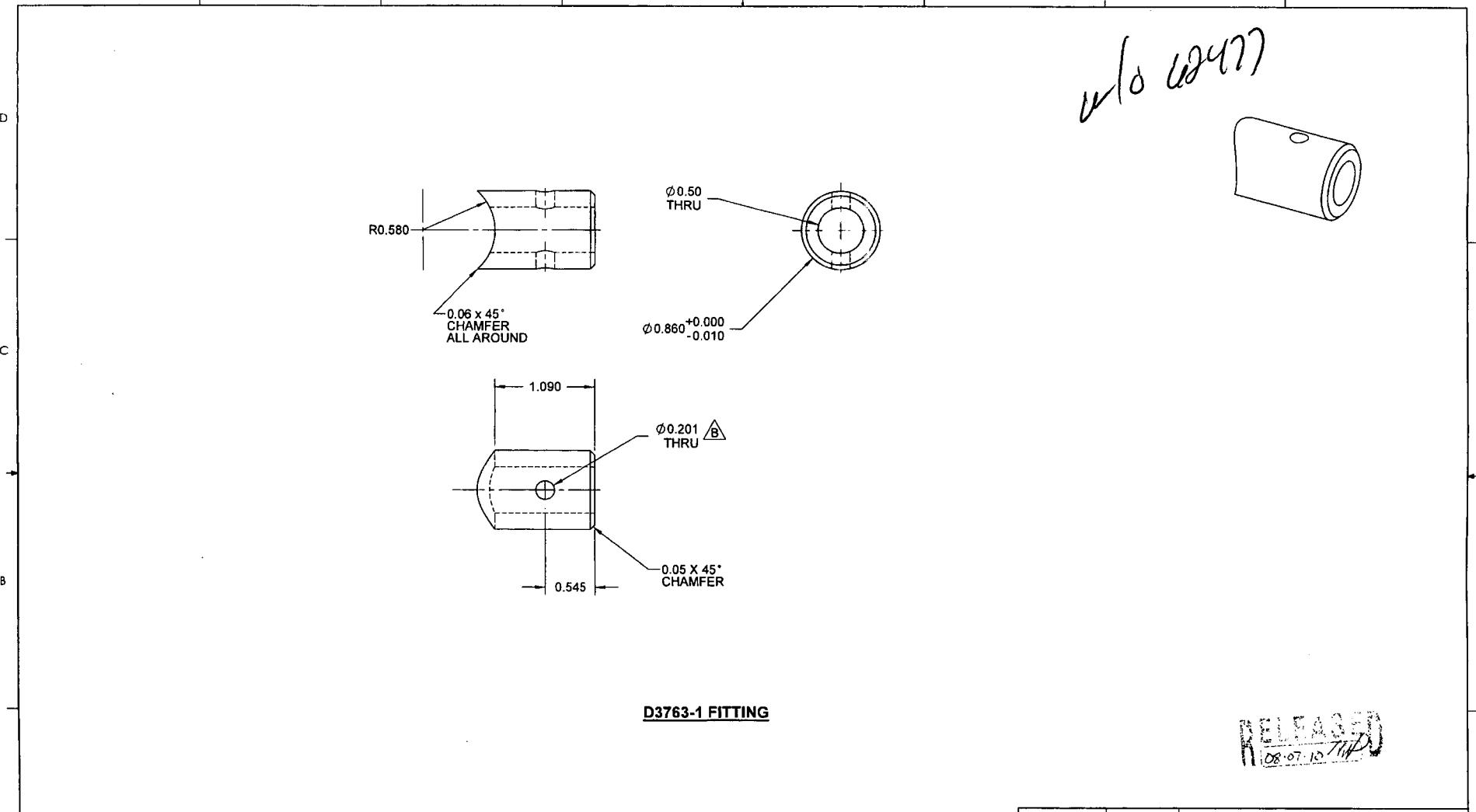
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

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CHECKED	<i>M</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>S</i>	D3763	SHEET 5 OF 9
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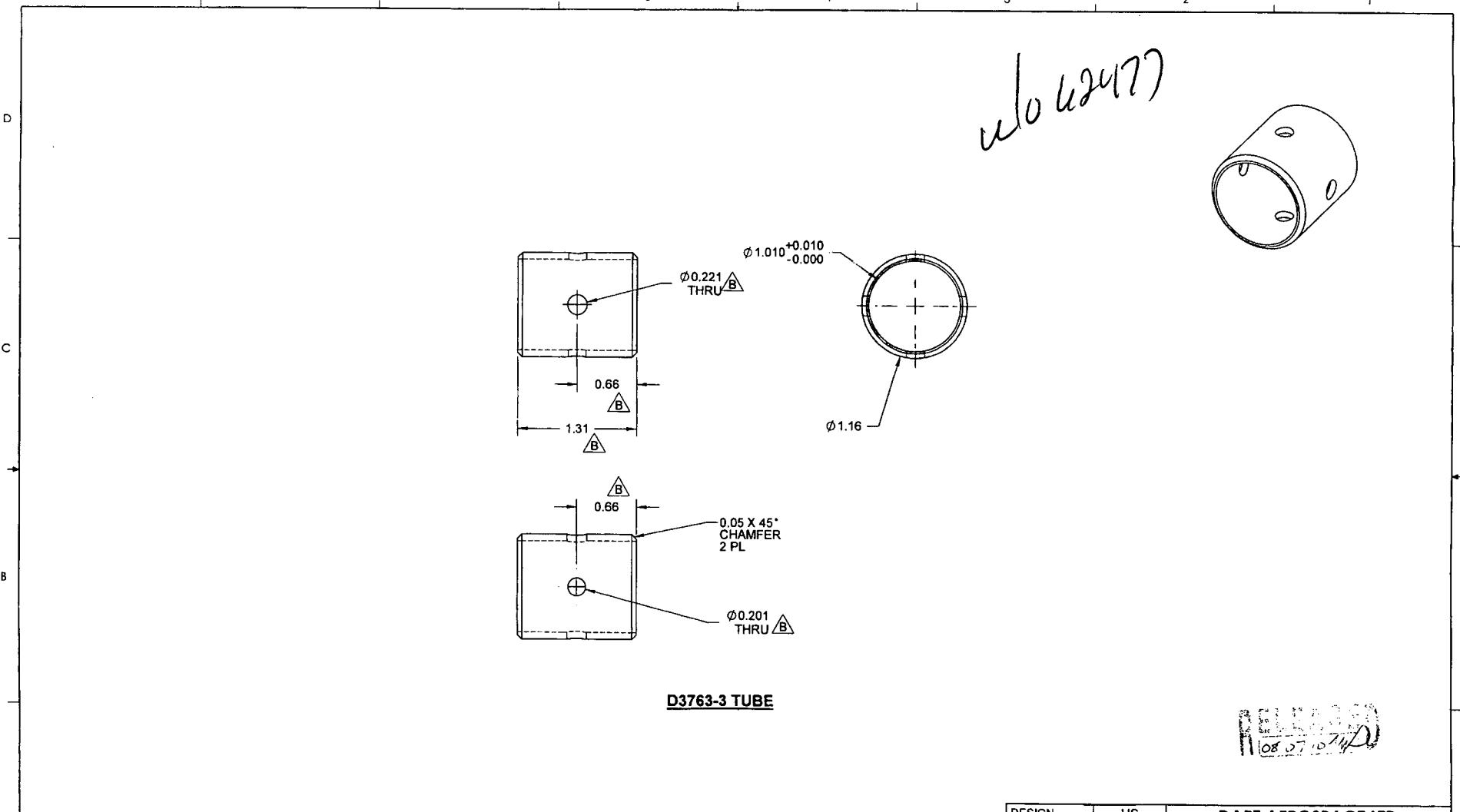
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D3763-3 TUBE

A NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

8 7 6 5 4 3 2 1

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. B	
MFG. APPR.		DRAWING NO.	
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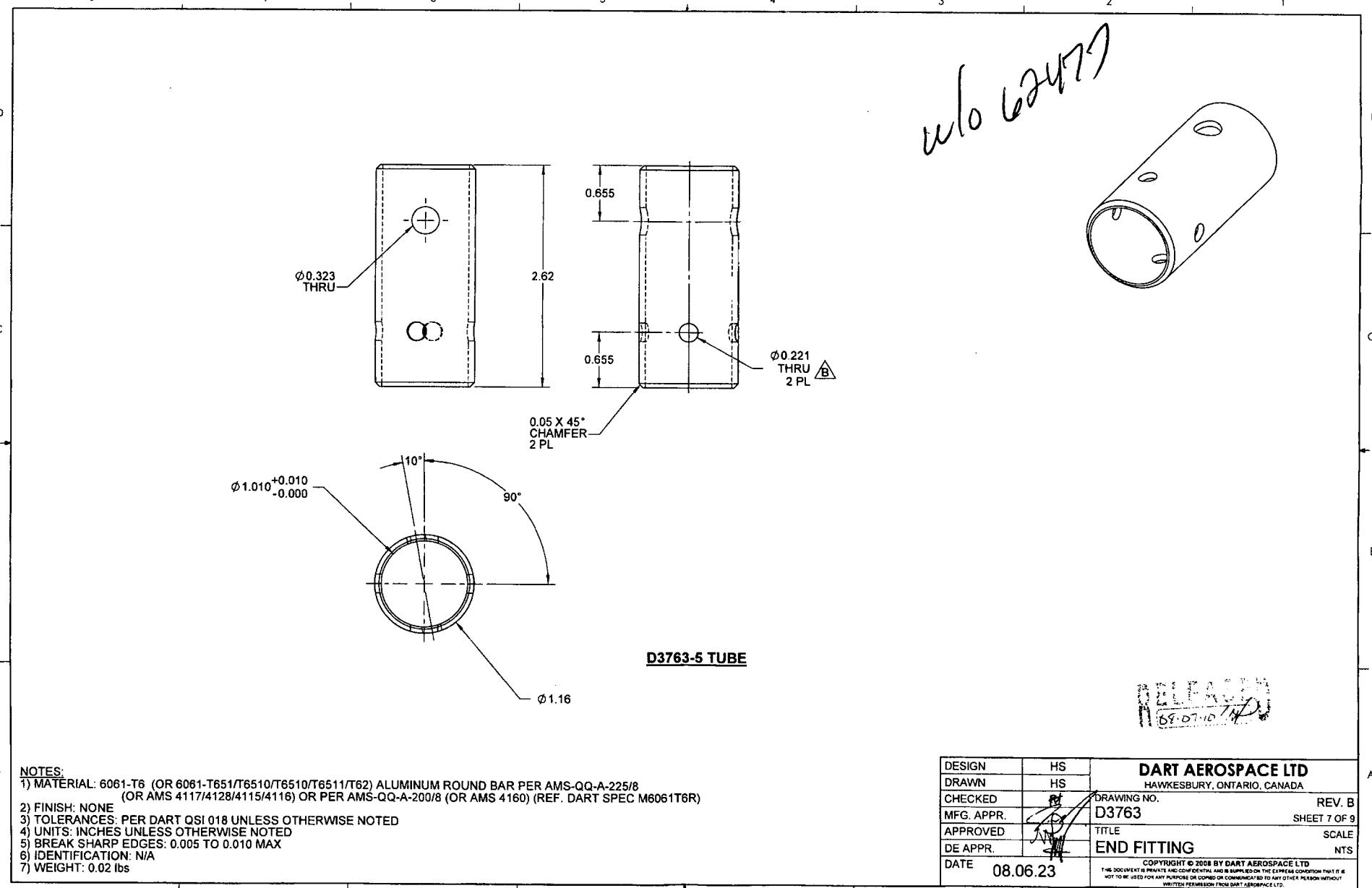
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NOTE: Date & initial all entries



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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

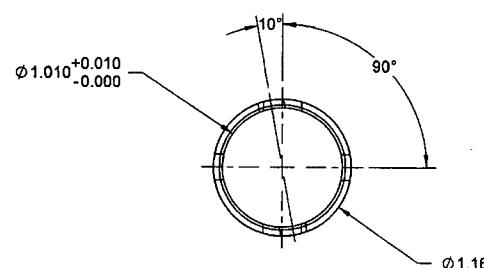
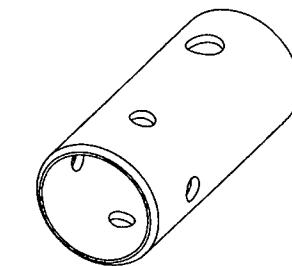
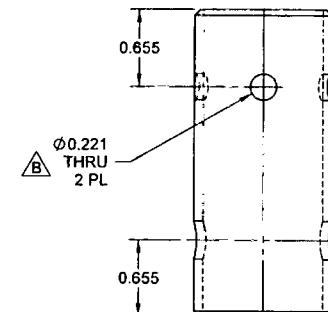
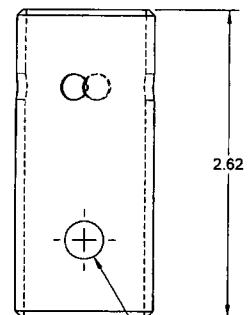
C

B

B

A

A

D3763-6 TUBE

RELEASER
08.07.2023

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

8 7 6 5 4 3 2 1

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
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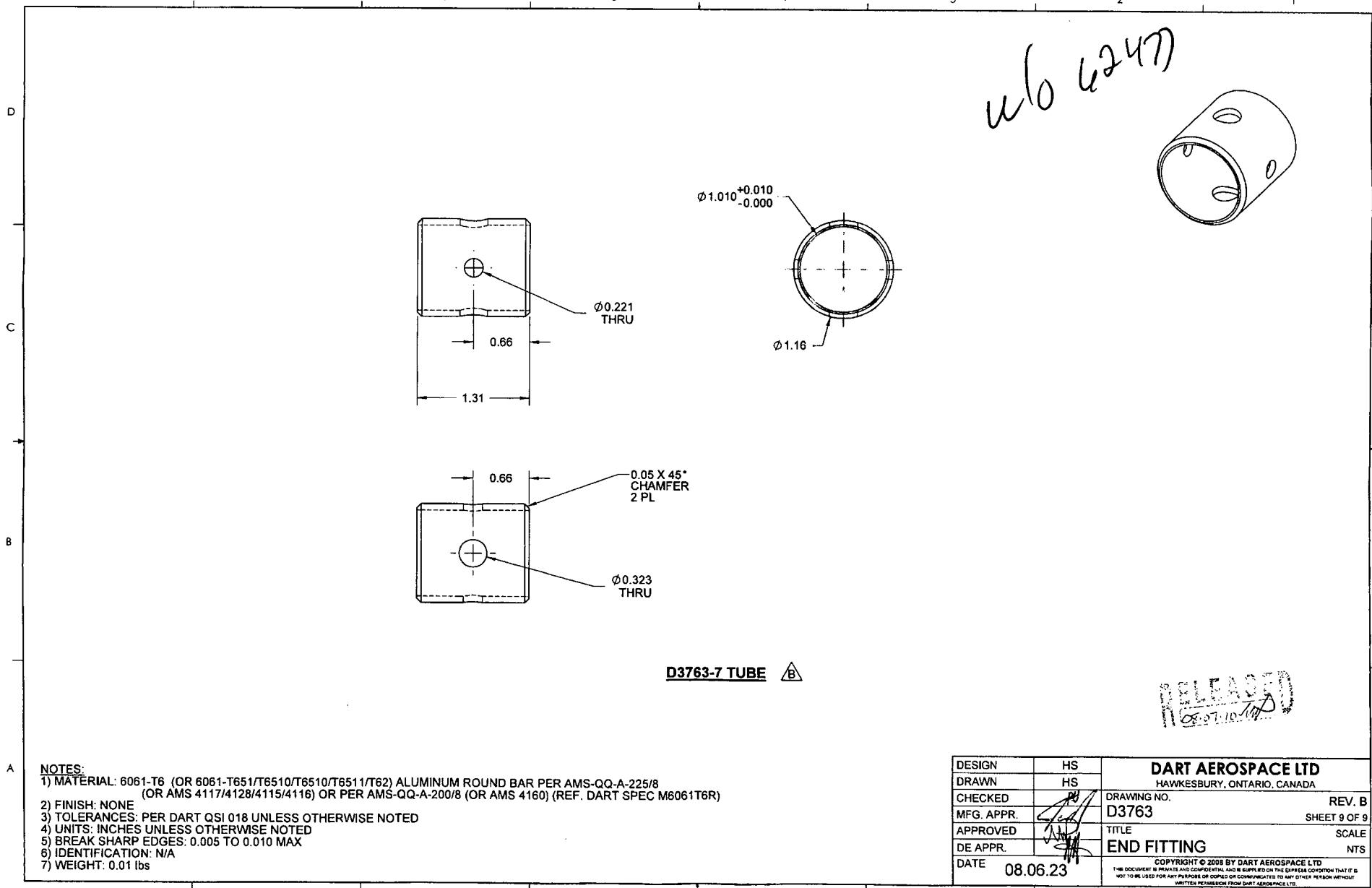
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